

Work Order ID 80511

80511

Page 1

February-22-12 9:59:52 AM

Item ID: D206-642-641

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube

Stop *NS2*

Start Date: 22/02/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/22 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr.

D3288

Rev G

100

0.00

100

DC

0.00

Document Control

Memo

Photocopy bluefile and create labels per PPP D206-642-641
CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center, ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110									
Skidtubes									
Skidtubes	Memo	0.00							
	1-Deburr FWD edge of tube, grind bending marks.								
	2-Remove ridge on inside of fwd edge of tube as per Dwg D3288.								
	3-Weld Fwd Cap as per Dwg D3288, Grind to obtain proper fit A/R AL ROD Batch: <u>M120164</u>								
	4-Grind welds flush to cap on top surface only.								
	5-Cut Aft end as per Dwg D3288 from front of tube then deburr								
	6-Remove inner indexing ridge on aft end as per Dwg d3288								
	7-Open holes for aft cap as per Dwg D3288 using DT8025								
	8-Drill pilot holes using DT8818								
	9- open float holes section J-J (6 per side) to 0.297" and aft cap holes to 0.208"								
	10-Insert D3286-1 doubler using DT8732 & DT8879, then locating doubler off the 3/16" holes cleco D3286-1 doubler remove DT8879								
	11-Working from center out, drill #30 holes into D3286-1 Doubler, cleco each hole after its drilled, Verify angle of holes to accomodate rivet heads.								
	12-Install DT8879 to hold doubler. Remove DT8732 then cleco doubler with #30 clecos. Remove DT8879 open GHW to 0.500"								

1 ~~0~~ CF 12.2.22

CF 10 12.2.22

OK 12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 07/03/2012 Req'd Qty: 1.00

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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13-Remove D3286-1 doubler, identify orientation, deburr then attach to W/O

14-Remove indexing edge as per Dwg D3288.

15-C'sink rivet holes as per Dwg D3288.

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

OK

12/02/23

12/02/23

OK

12/02/23

W/O:		WORK ORDER CHANGES					
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NS2

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00

140

QC

QC7

Memo

0.00

Quality Control

BB

12/02/13

SAD

150

0.00

150

Skid tubes

Skid tubes

Memo

0.00

1-Open Holes to finished size as per DWg D3288. Debur.

2-Locate, install and rivet doublers using DT8879 as per Dwg D3288. Micro-shave rivets as required.

3-Bond web in place as per Dwg D3288 & QSI 015.
A/RSikaflex-291 *119999*

Sikaflex expire date: *12/08/13*
Start: *12/02/12* Time: *8:37*
Finish: *12/02/12* Time: *2:00*
(Adhere for 12 hours)

DL 12/02/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/02/23	140	QC3 to QC7 see w/o 78681	BB	12/02/23				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 80511***80511***

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NS1

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Stop

NS2

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control



12-2-27

170

0.00

170

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube using program D3288 as per Dwg D3288. Install drop pins in cross bolt spacer holes to maintain web position.



12-2-27

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 80511

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

0.00

Skidtubes

Memo

1-Drill pilot holes for wearplates using D3288-T2 as per Dwg D3288, then open to Ø0.297". (without cutting fluid)
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

2-C'sink X-bolt holes.

3-Deburr and remove alodine as required for welding

B 12/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80511

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February-22-12 9:59:52 AM

Item ID: D206-642-641 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube
 Start Date: 22/02/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 07/03/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0.00

190

Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3288. Remember to back drill each hole before welding the other side. Use aluminum rod.
 A/RAluminum Rod M20/64 BE 12/02/28

2-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3288. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required
 A/RSS Rod NONE BE 12/02/28

3-Grind cross bolt welds flush as per Dwg D3288. Masking Tape access to inside of the skidtube

4-Counterbore 5/16" x 0.750" deep using DT8747, except 8th cross bolt hole from Aft end, as per Dwg D3288.

BB 12/02/28

ND 12-2-28

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Quality Control

Memo

0.00

QC10

- 8/2/28
- 8/2/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 80511

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Item ID: D206-642-641

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N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Replacement Skidtube

Stop ***NS2***

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC9- Inspect visual per QSI004- Fusion Welds

0.00

210

QC

Memo

0.00

Quality Control

PA 12.02.29

220

0.00

220

HandFinish

Memo

0.00

Hand Finishing

1 & BL (DP) 12/03/01

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

230

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*12:50
3200F
1:20*

1XJ m 12/03/01

m 120222

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 80511

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Item ID: D206-642-641

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

Stop

NS2

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC3- Inspect Part Finish

0.00

240

QC

Memo

0.00

Quality Control

1 of 1 11/03/01

250

0.00

250

HandFinish

Memo

0.00

Hand Finishing

1-Install D3415-041 Nut Plate as per Dwg D3288 ,Install with LPS-3
A/R LPS-3 Batch: 1111596

2-Install inserts Dwg D3288. Use a drop of Sikaflex inside insert holes
A/RSikaflex-291 11119508
Sikaflex expire date: 12/08

1 of 1 11/03/02

260

QC5- Inspect part completeness to step on W/O

0.00

260

QC

Memo

0.00

Quality Control

8 12/03/02

Ⓢ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 80511

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Item ID: D206-642-641

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Skidtube

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NS2

Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

HandFinish

Memo

0.00

Hand Finishing

- ✓ 1-Install wearshoes/wearpads & Gaskets as per Dwg D3288.
- ✓ 2-Install Ring on Nut Plate as per detail F & Dwg D3288.
- ✓ 3-Spray inside tube with LPS-3 on both sides of web
- ✓ 4-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive.
A/RSikaflex-291 11119508
Sikaflex expire date: 12/08
- ✓ 5-Coat all exposed fastners with LPS Procyon, remove any excess on powder coat with MEK Degreasser.
A/R LPS Procyon Batch: 11114546

1 6 12/03/07

280

QC5- Inspect part completeness to step on W/O

0.00

280

QC

Memo

0.00

Quality Control

8 12/03/02

W/O:		WORK ORDER CHANGES					
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Item ID: D206-642-641

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Setup Start *NS1*

Revision ID:

Stop *NS2*

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Start Date: 22/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 07/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290		0.00							
290									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-641								
	Location: _____								
	PPP Rev: _____								
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

443/6 ①

12/3/17

MF
12-03-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B05.11.15 Added washers for aft cap, wearshoes and ringEC
 IPP Rev:C 06-05-31 Revised steps JLM
 IPP Rev:D 07-02-22 Added SS Wearplates & Gaskets JLM
 IPP Rev:E 07-12-06 ECN 1080p DD verified by:ec
 IPP Rev:F 08-04-17 as per PAR 08-015 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	40.0000	1	1			
<p>*D2620*</p> <p>Skidtube, 206 Skidtube</p>													
<p>Location Loc Qty Loc Code</p> <p>LG 40</p> <p>77996 1</p> <p>77999 10</p> <p>78000 8</p> <p>79542 2</p> <p>79543 3</p> <p>79544 10</p> <p>79545 6</p>													

D2647		Manufactured	No			110	Each	79.0000	1	1			
<p>*D2647*</p> <p>Cap</p>													
<p>Location Loc Qty Loc Code</p> <p>LG002 79</p> <p>75482 79</p>													

① CF 12.2.22

BE 12/02/22

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube

80511

D206-642-641

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3286-1

Manufactured No

110 Each

133.0000 2 2

D3286-1

Doubler

**

OK 12/02/23

Location

Loc Qty

Loc Code

LG002

229

74872

6

78014

105

ST046

-96

76772

22

CR3212-4-04

Purchased No

150 Each

8,089.000 52 52

CR3212-4-04

Cherry Rivet

**

OK 12/02/24

Location

Loc Qty

Loc Code

ST331

184

116471

78

117816

3

118686

1

118840

16

119017

76

119075

10

st510

7905

119075

7905

D3289-041

Manufactured No

150 Each

0.0000 1 1

D3289-041

Float Web (206A/B)

**

OK 12/02/24

B80167

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-22-12 9:59:56 AM

Page 3

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

728.0000

9

9

D2649

Cross Bolt Spacer

*BE 12/02/28
B79504 *9*

Location

Loc Qty

Loc Code

LG

601

77574

2

78019

199

79503

400

LG001

127

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

D3275-1

Manufactured No

190

Each

228.0000

6

6

D3275-1

Crossbolt Spacer

BE 12/02/28

Location

Loc Qty

Loc Code

LG002

228

66930

106

73393

70

74437

52

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3286-3

Manufactured No

190

Each

153.0000

2

2

D3286-3

Spacer

**

B/E 12/02/28

Location

Loc Qty

Loc Code

LG

43

78015

43

2

LG001

110

74117

1

79557

109

D3415-041

Manufactured No

250

Each

28.0000

1

1

D3415-041

Nut Plate

**

Y/L 12/03/01

Location

Loc Qty

Loc Code

ST042

28

67605

28

Y/L

CCR264SS3-3

Purchased No

250

Each

797.0000

2

2

CCR264SS3-3

Cherry Rivet

**

Y/L 12/03/01

Location

Loc Qty

Loc Code

ST331

797

113973

2

117849

135

119017

660

Y/L

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-22-12 9:59:57 AM

Work Order ID: 80511

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube

80511

D206-642-641

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

250

Each

1,550.000

2

2

CR3212-4-03

Cherry Rivet

**

HL 12/03/01

Location

Loc Qty

Loc Code

FP002

560

114859

560

x2

ST331

990

110139

2

119017

988

ALS7-1032-130

Purchased

No

250

Each

2,472.000

64

AI S7-1032-130

Insert

**

64 76 64
11/12/06 71 176 111 12/03/01

ALS4-1032-130

Location

Loc Qty

Loc Code

ST280

328

117717

27

118966

22

119775

279

ST281

71

119794

71

ST282

2073

119530

73

120181

2000

D3535-15

Manufactured

No

270

Each

20.0000

1

1

D3535-15

Wearshoe

**

HL 12/03/01

Location

Loc Qty

Loc Code

FP001

20

73315

8

74512

12

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-22-12 9:59:57 AM

Page 6

Work Order ID: 80511

Parent Item: D206-642-641

Parent Item Name: Replacement Skidtube

80511

D206-642-641

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-21

Manufactured No

270 Each

25.0000

1

1

D3535-21

Wearshoe

**

HL 12/03/01

Location

Loc Qty

Loc Code

FP001

7

70380

7

✓1

FP002

18

78987

18

D3535-35

Manufactured No

270 Each

23.0000

1

1

D3535-35

Wearshoe

**

B80332(r) HL 12/03/01

Location

Loc Qty

Loc Code

FP001

23

67598

1

70815

1

74509

8

78873

13

D3535-41

Manufactured No

270 Each

13.0000

1

1

D3535-41

Wearshoe

**

HL 12/03/01

Location

Loc Qty

Loc Code

FP001

13

42256

13

✓1

D3536-15

Manufactured No

270 Each

22.0000

1

1

D3536-15

Gasket

**

HL 12/03/01

Location

Loc Qty

Loc Code

FP002

22

73318

22

✓1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3536-21	Manufactured	No	270	Each	29.0000	1	1
D3536-21						**	<u>12/03/01</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	29	
70464	5	
78966	24	

D3536-35	Manufactured	No	270	Each	19.0000	1	1
D3536-35						**	<u>12/03/01</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	19	
73313	5	
74511	14	

D3536-41	Manufactured	No	270	Each	15.0000	1	1
D3536-41						**	<u>12/03/01</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	15	
37353	3	
51646	12	

D3537-1	Manufactured	No	270	Each	87.0000	7	7
D3537-1						**	<u>12/03/01</u>
Wearpad							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	68	
78592	68	
FP002	19	
69817	5	
78591	14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-3

Manufactured No

270

Each

30.0000

1

1

D3537-3

Wearpad

**

HL 12/03/10

Location

Loc Qty

Loc Code

FP002

30

74500

25

76986

5

XL

AN3C4A

Purchased

No

270

Each

3,914.000

66

66

AN3C4A

BOLT

**

HL 12/03/10

Location

Loc Qty

Loc Code

ST350

3914

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187

2000

120423

354

120521

1000

120769

515

V166

NAS1515H3L

Purchased

No

270

Each

220.0000

2

2

*NAS1515H3I *

WASHER

**

HL 12/03/10

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

180

118686

3

119438

1

120072

76

120360

100

V2

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Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 78 78

AN960C10I ~~X~~

washer

**

M120648 (x78) M120301

D3683-1 Manufactured No

270 Each 8,675.000 12 12

D3683-1

Insert

**

M120303

Location

Loc Qty

Loc Code

FP002

8675

36319

8675

D3413-1 Manufactured No

270 Each 109.0000 1 1

D3413-1

Ring

**

M120301

Location

Loc Qty

Loc Code

ST420

22

70773

1

79233

21

ST464

87

75478

12

76754

43

77940

32

AN4C5A Purchased No

270 Each 316.0000 1 1

AN4C5A

BOLT

**

M120301

Location

Loc Qty

Loc Code

FP002

2

112243

2

ST355

314

112243

214

119017

100

February-22-12 9:59:57 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 80511

80511

Parent Item: D206-642-641

D206-642-641

Parent Item Name: Replacement Skidtube

Start Date: 22/02/2012

Required Date: 07/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C416 NAS1149C0463 Purchased No

270 Each 0.0000 1 1

AN960C416

washer

**

1117735(x1) 12/03/01

D2646

Manufactured No

270 Each 87.0000 1 1

D2646

Aft Cap

**

12/03/01

Location

Loc Qty

Loc Code

FP002

87

62678

5

68280

5

70945

1

71070

2

73294

1

73825

23

78018

50

MS27039C1-05

Purchased No

270 Each 211.0000 12 12

MS27039C1-05

SCREW

**

12/03/01

Location

Loc Qty

Loc Code

ST293

211

106574

12

107242

199

x12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2646	AFT CAP
1	D2647	CAP
9	D2649	CROSS BOLT SPACER
6	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
12	D3683-1	INSERT
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
78	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
12	MS27039C1-05	SCREW (or AN3C3A BOLT)
2	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: N/A
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: 20.8 LBS
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES EXCEPT WHERE SHOWN
- DRILL Ø0.297 HOLES FOR D3683-1 INSERTS BEFORE FINISH. INSTALL D3683-1 INSERTS AFTER FINISH
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/291
- WELDING: PER DART QSI 004
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

805.11 M.C.J
12/02/22

RELEASED
09/06/2004

G	REFORMAT DWG, RMV LPS-3 (ZN B6-3) RMV C'BORE & ADD SECTION K-K (ZN C2-4)	CP	09.06.17
F	SUBSTITUTE FLOAT BAG INSERT W/SPEC CTRL DWG WAS ALS7-1032-130, IS NOW D3683-1	DC	07.11.21
E	MID-FLOAT HOLES WERE MOVED 2.00" FWD AND ROTATED INBOARD AND OUTBOARD BY 17" INSERTS ARE NOW INSTALLED AT THESE LOCATIONS	MB	07.09.14
D	DIMENSIONS ADDED	DC	07.08.04
C	NEW INSERTS, SS WEARSHOES AND GASKETS	PH	06.12.19
B	CHANGE INSERTS	CP	05.03.18
A	NEW ISSUE	CP	04.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. G
D3288 SHEET 1 OF 4
TITLE SCALE
SKIDTUBE ASSEMBLY NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

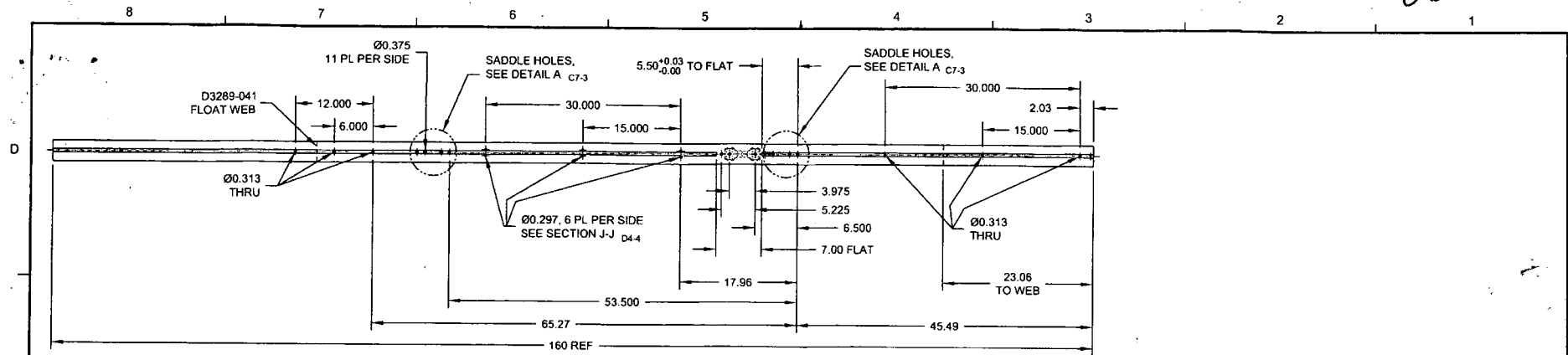
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

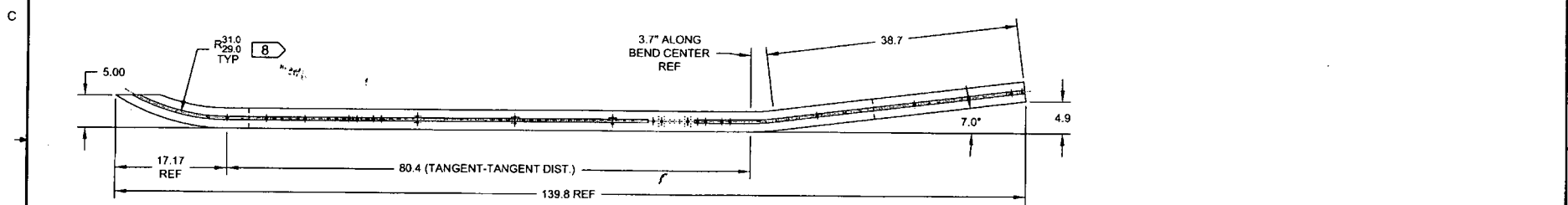
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

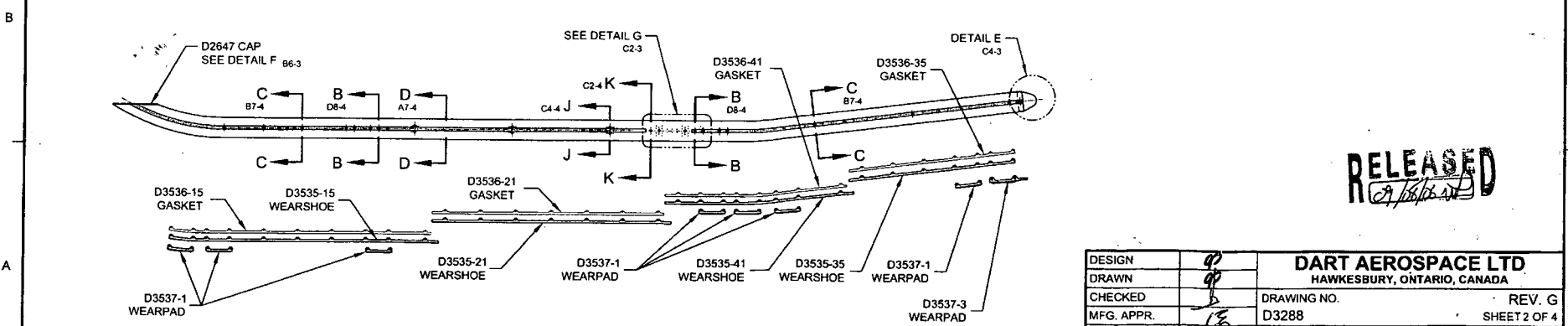
80571



D3288-041 DRILLING/WEB ASSEMBLY DETAIL



D3288-041 BENDING DETAIL



D3288-041 WELDING DETAIL/SKIDTUBE ASSEMBLY

RELEASED

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. G
MFG. APPR.	92	D3288	SHEET 2 OF 4
APPROVED	92	TITLE	SCALE
DE APPR.	92	SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

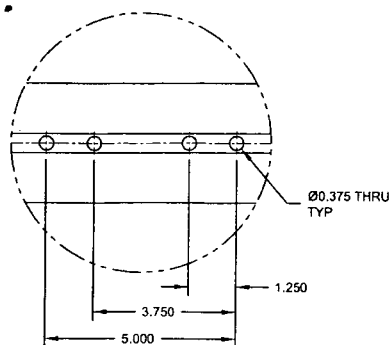
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

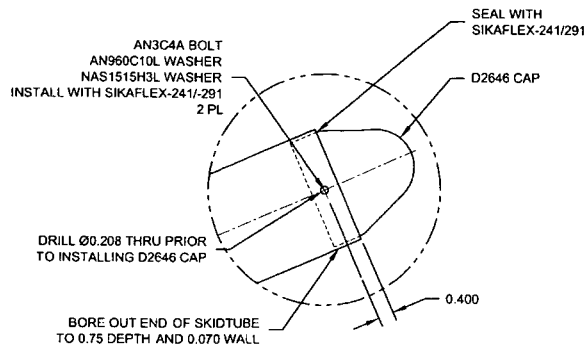
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

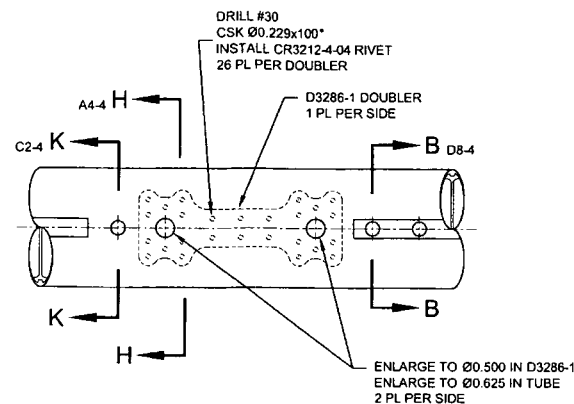
NOTE: Date & initial all entries



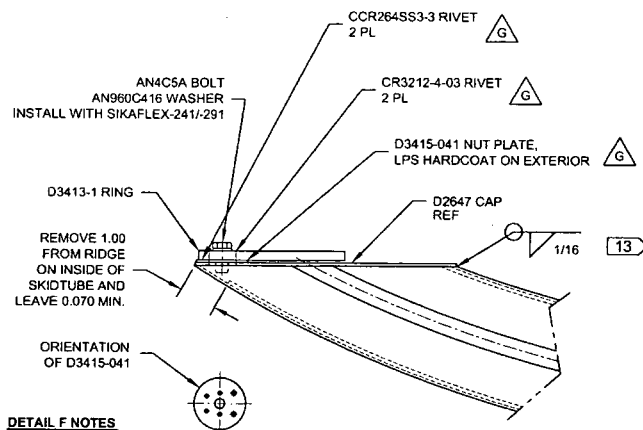
DETAIL A: DRILL DETAIL
SADDLE HOLES, SCALE 5X



DETAIL E
SCALE 5X



DETAIL G
SCALE 5X



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DETAIL F: END FINISHING DETAIL
SCALE 5X

RELEASED
09/06/17

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

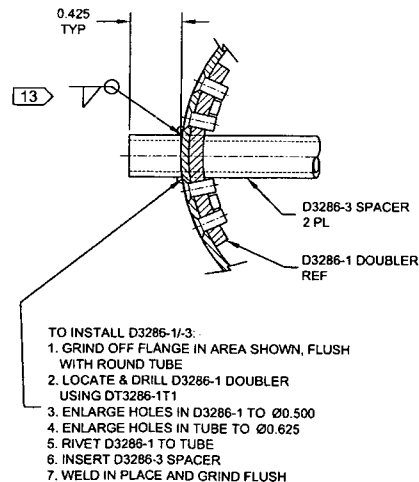
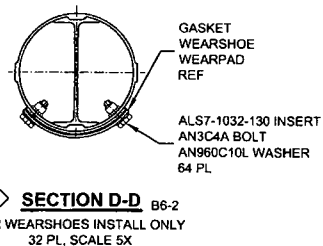
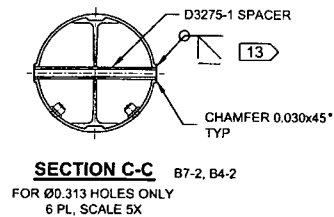
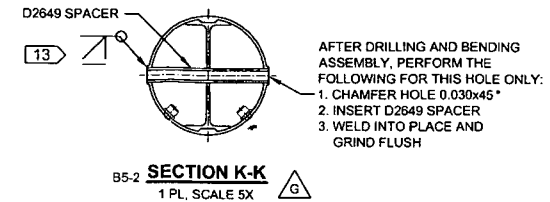
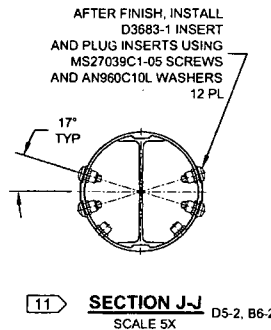
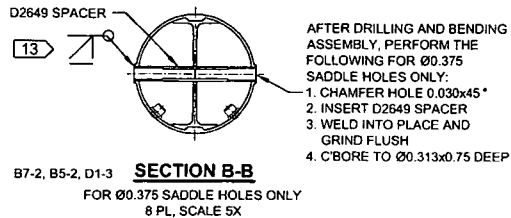
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

805711



RELEASED

DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3288	SHEET 4 OF 4
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 281

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 77988
Part number: A206-642-151
Description: SKID Lube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 12-01-23
Welder Barclay Elliot Date of Test Coupon 12-01-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld